Work Order ID 50834

July 23, 2009 7:38:17 AM

Item ID: D205-634-041 **Accept** **Setup Start** **Stop**

Revision ID: D

Item Name: Replacement Skidtube

Start Date: 07/30/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 08/07/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** mf **Date:** 09-07-23 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2580	Rev D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041				CHG002	cnto w/o 51029	N/A		
110	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	**Memo**	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009 2-Cut tubes as per Dwg. D2580								

9-7-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

Work Order ID 50834

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Start Date: 07/30/2009 **Start Qty:** 1.00 **Cust Item ID:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				1	ϕ	– AWM 7-7-27	
Skidtubes	**Memo**	0.00							
Skidtubes	1- Deburr ends 2- C'sink holes as per dwg without cutting fluid 3- Prepare tube for welding, remove alodine as required. 4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00				(10)	ϕ		
QC	**Memo**	0.00							
Quality Control									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
Skidtubes		0.00							
Skidtubes	**Memo**								

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod M111679 BE 09/07/28

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod M111679 BE 09/07/28

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

BE 09/07/29

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W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00				(10)	0		
160 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(10)	0		
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00				09-08-04 (1).			

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W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 11:25am OVEN TEMPERATURE: 320°F FINISH TIME: 11:55am M112148 09-08-04 (X1)								
190	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control	BH 09-08-6 — 0.								

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Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube
Start Date: 07/30/2009 **Start Qty:** 1.00
Required Date: 08/07/2009 **Req'd Qty:** 1.00
Reference:

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Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00				X1			
HandFinish		0.00							
Hand Finishing	**Memo**								

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐☐☐ Sikaflex-291 ☐ M111557
Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐☐ Sikaflex-291 ☐ M111557
Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M112106

UMD 09/08/06

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Item Name: Replacement Skidtube

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPPD205-634-041 Location:_____ PPP Rev:_____								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

PPP

51029 9/8/7 (12) 80

09.08.12

MF 09-08-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:38:17 AM

Work Order ID: 50834

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009 **Required Date:** 08/07/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	1.0000	1.0000			
205 Skidtube bent detail												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1	
48616	1	

B50760 BE 9-7-28

D2576-3RevG		Manufactured	No			140	Each	168.0000	1.0000			
Step (maching detail)												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	168	
43504	65	
46661	103	

1 BE 9-7-28

D2579RevE		Manufactured	No			140	Each	512.0000	20.0000			
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	512	
43988	4	
46434	4	
46956	12	
47797	438	
48272	54	

(20) AGM 9-2-27

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 50834

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009 **Required Date:** 08/07/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	15.0000	1.0000			
Cap												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	50513	
ST	15	
10360	2	
35663	7	
41340	1	
42343	3	
42806	2	

x1 UMD 09/08/06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,562.000	2.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	2562	
100188	246	
105057	2246	
15205	70	

x2 UMD 09/08/06

Dart Aerospace Ltd

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			200	Each	7,073.000	2.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	7157			
101291	16			
104885	153			
105793	236			
~~109632~~	1752		X2	UMO 09/08/06
110985	5000			
Main Warehouse				
ST182	-84			
109632	-84			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,850.000	50.0000			
Insert												

Warehouse Location	Loc Qty	Loc Code		
110511				
Main Warehouse				
ST	3850		X50	UMO 09/08/06
108606	52			
111529	1798			
111779	2000			

Dart Aerospace Ltd

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Comments:

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Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			200	Each	152.0000	50.0000			
BOLT												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	112314	
ST	152	
112082	152	

x50 CMD 09/08/06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			200	Each	4,758.000	50.0000			
washer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	4758	
103585	100	
112116	4658	

X50 CMD 09/08/06

Dart Aerospace Ltd

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D3566-13RevC		Manufactured	No			200	Each	32.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP17	-1	
46889	-1	
Main Warehouse		
ST	33	
45717	1	
46889	6	
47435	8	
48166	18	

XI UMD 09/08/06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			200	Each	23.0000	1.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	23	
36113	1	
46186	1	
47318	1	
48167	20	

XI UMD 09/08/06

Dart Aerospace Ltd

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Parent Item Name: Replacement Skidtube

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			200	Each	24.0000	2.0000			
Gasket												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse	50278	
ST	24	
46349	1	
47434	2	
48165	10	
48557	11	

X2 UMD 09/08/06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	21.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	21	
45823	1	
47432	8	
48553	12	

X1 UMD 09/08/06

Dart Aerospace Ltd

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:38:17 AM

Work Order ID: 50834

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009 **Required Date:** 08/07/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	34.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP17	13		
48554	13		X1 UMD 09/08/06
Main Warehouse			
ST	21		
45409	3		
46495	10		
47867	8		

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	18.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	18		
44659	1		
45825	1		
47316	4		
48556	12		X1 UMD 09/08/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:38:17 AM

Work Order ID: 50834

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009 **Required Date:** 08/07/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	23.0000	1.0000			
Wearshoe												

Warehouse Location	Loc Qty	Loc Code		
OFFSHORE				
FG	2			
34806	2			
Main Warehouse				
FP19	12			
48555	12		X1	UMD 09/08/06
Main Warehouse				
ST	9			
45824	1			
47433	1			
48164	7			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	918.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	918			
27168	44			
29908	874		X16	UMD 09/08/06

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:38:17 AM

Work Order ID: 50834

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009 **Required Date:** 08/07/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	716.0000	16.0000			

Plug, 205 Skidtube

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	716		
42221	16		
42807	92		
43884	103		
46435	3		
47251	502		x16 UMD 09/08/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED
07 06 28

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
 SEE NOTES ON
 PAGE 2 FOR D2580-041 AND
 PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

4 5087

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

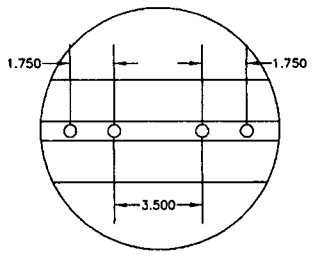
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

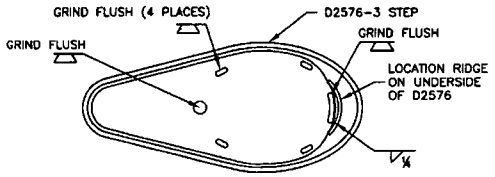
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

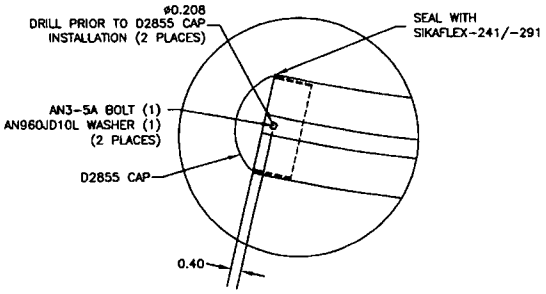


DETAIL B
SCALE 5:24

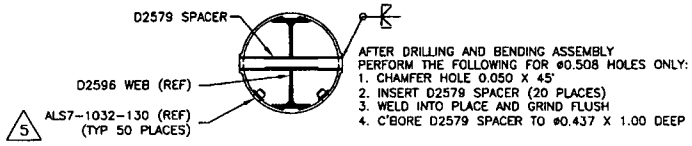


RELEASED
07.06.28

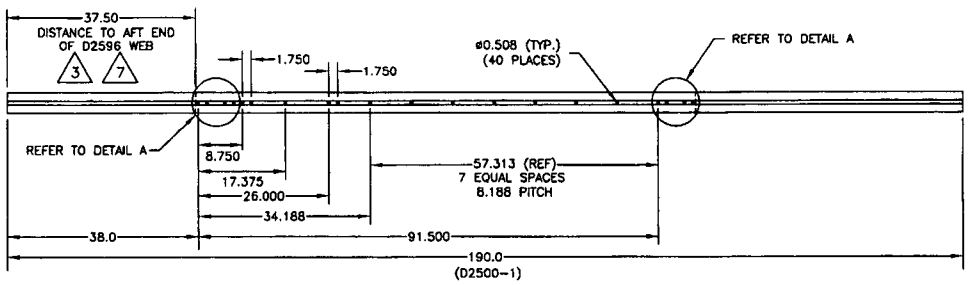
DETAIL C
SCALE 5:24



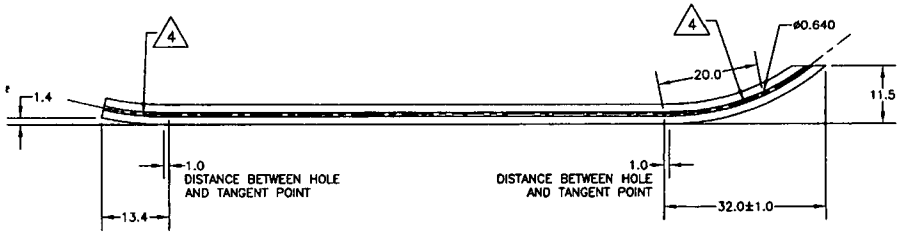
SECTION D-D
SCALE 5:24



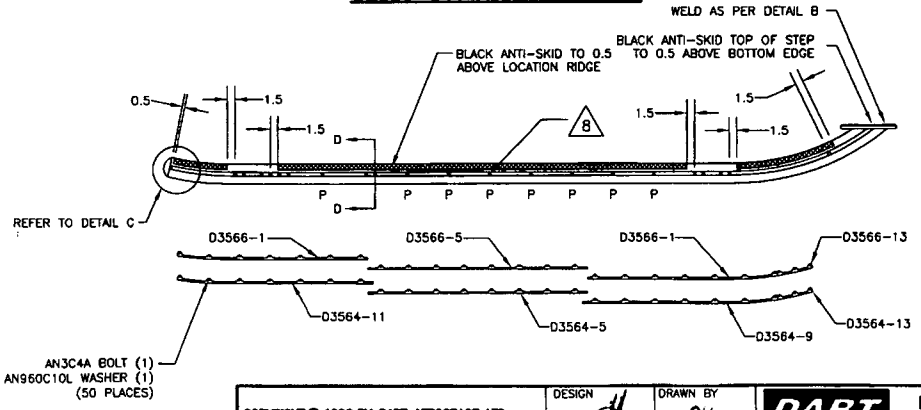
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 REV. D
DATE 07.02.27		SHEET 2 OF 3
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

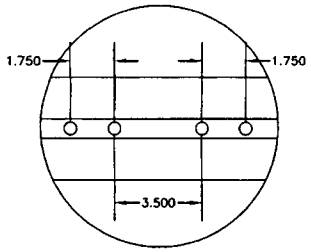
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

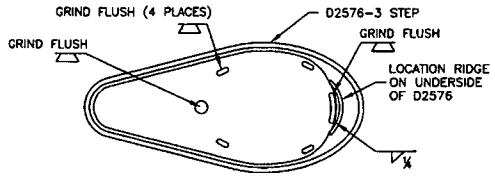
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

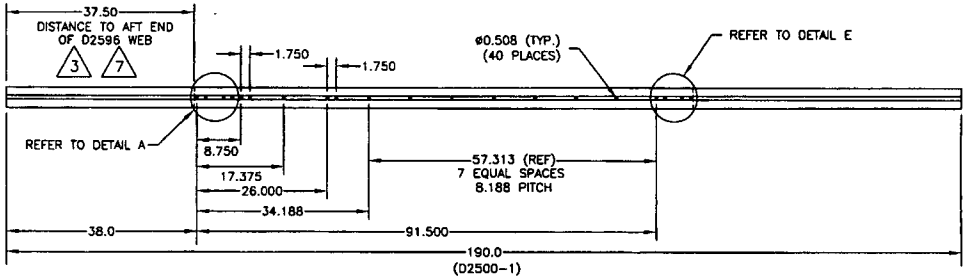


DETAIL F
SCALE 5:24

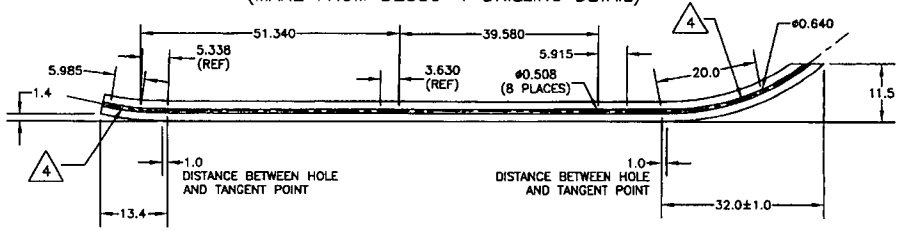


RELEASED
07 de 28

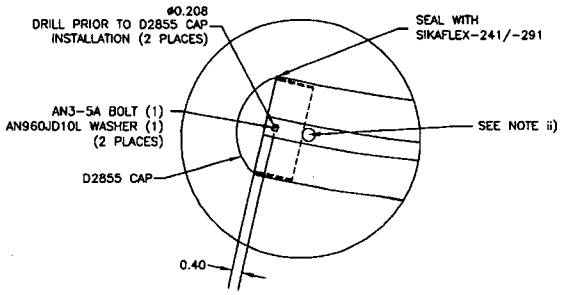
D2580-1 DRILLING DETAIL



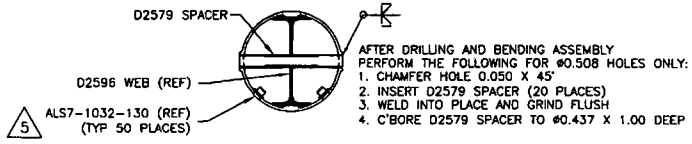
D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



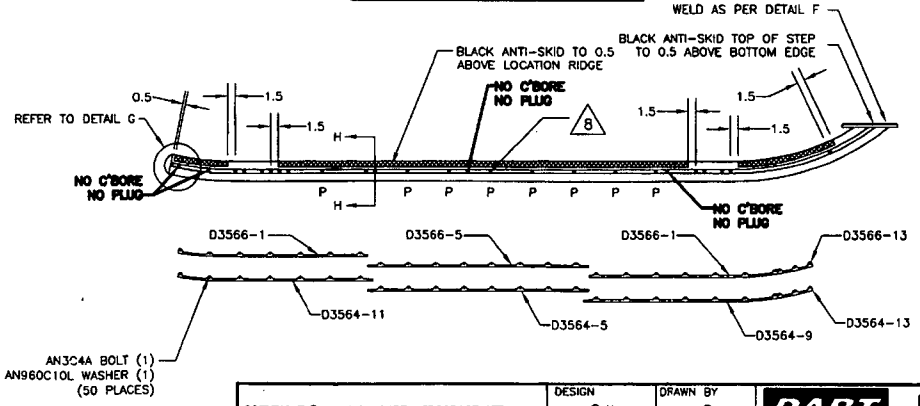
DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24



D2580-045 ASSEMBLY DETAIL



C

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
RH	RH	
CHECKED	APPROVED	DRAWING NO. D2580 — REV. D — SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY — SCALE 1:24

NO. 202

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 48448A
Part number: D805B34 041
Description: 205 skid tube
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminium
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[✓] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

REFERENCE ONLY

Qualifier Rod Dal **Date of Test Coupon** 09.06.17

Welder Barclay Elliott **Date of Test Coupon** 09.06.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld